

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 32483		
Estimate Number	: 12825		
P.O. Number	: <i>N/A</i>	Part Number	: D3578041
This Issue	: 5/23/2007	Drawing Number	: D3578 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: A
Previous Run	: 31865	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/31/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	60 Um: Each
Comment	: Est: A 07.04.11 New issue EC		

Job Number:

1.0 M6061T6S080 6061-T6 .080 Sheet

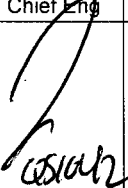
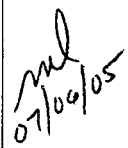
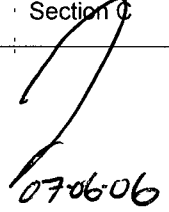

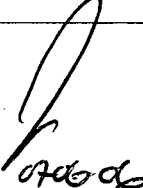
Batch: 1704392 ml 07.06.04

.2-Deburr if necessary

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	5						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/05	5 and 6	at step 5 I counted 60 lost 1 some were between GA and finishing		Qty 59.	 07/06/05	 070606	 070606	 070606

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:26:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32483

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



COUNTED

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

118

07-06-05 (59)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/05 (X59)

8.0

MS21075L3

Nutplate



59

Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nutplate

Batch: 11534

9.0

MS20426AD33

Rivet



118

Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

1563

07/06/05 (59)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3578

ml 07/06/05 (X59)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/06/05 (59)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 574A

07/06/05 (59)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(59)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/06

Job Completion



W 07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

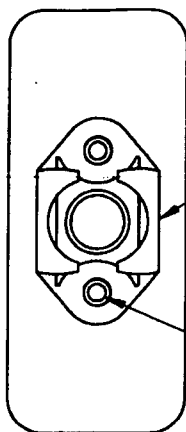
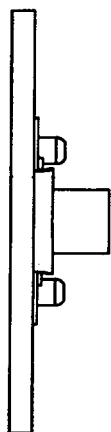
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12		TITLE DOUBLER SCALE 3:2	
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



D3578-1 PLATE

MS21075L3 NUT PLATE

MS20426AD3-3 RIVET
(2 PLACES)

RELEASED
07.04.02

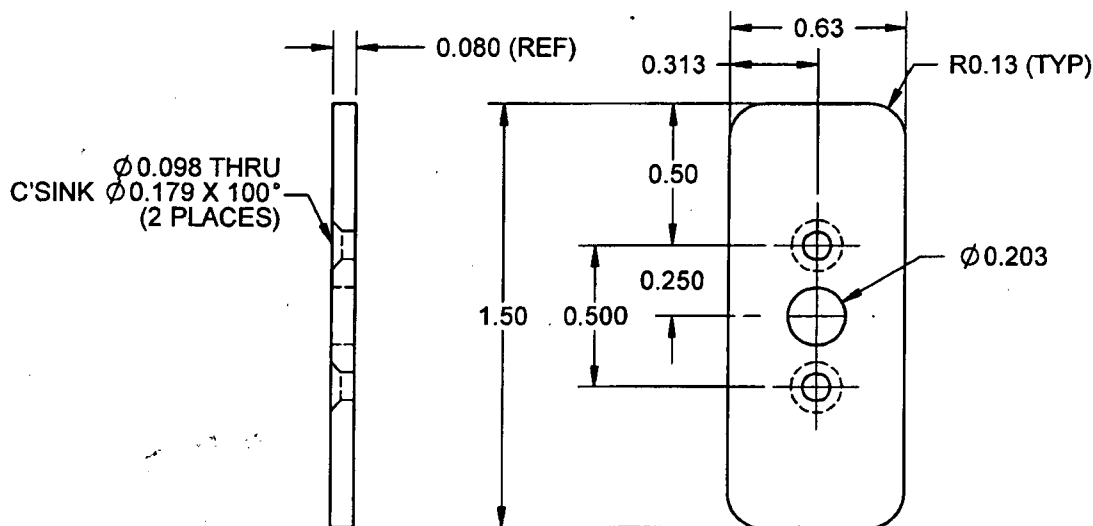
D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32483



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DART AEROSPACE LTD		Work Order: 32483
Description: Doubler		Part Number: D3578-011
Inspection Dwg: D3578	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.080	+/-0.010	0.080	✓		VERN	
B Ø 0.203	+0.005-0.001	0.205	✓		VERN	
C 0.63	+/-0.030	0.634	✓		VERN	
D Ø 0.098	+0.004-0.001	0.100	✓		VERN	
E 1.50	+/-0.030	1.508	✓		VERN	
F 0.500	+/-0.010	0.501	✓		VERN	
G 0.50	+/-0.030	0.505	✓		VERN	
H 0.250	+/-0.010	0.251	✓		VERN	
I R0.13	+/-0.030	R0.13	✓		VERN	
J 0.313	+/-0.010	0.315	✓		VERN	
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: M. M	Audited by: J. F	Prototype Approval:	N/A
Date: 07/06/04	Date: 07/06/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

